

Date: Friday, 25/04/2008 8:21:56 AM  
User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 38787  
Estimate Number : 12300  
P.O. Number :  
This Issue : 25/04/2008 S.O. No. :  
Prsht Rev. :  
First Issue :  
Previous Run : 38466  
Type : MACHINED PARTS  
Written By : *JLM 08.04.25*  
Checked & Approved By :  
Comment :  
Est Rev: A New Issue 06-02-28 JLM  
Est Rev: B As per Rev B 06-03-30 JLM  
Est Rev: C Now On Doosan Lathe JLM Verified BY: DD

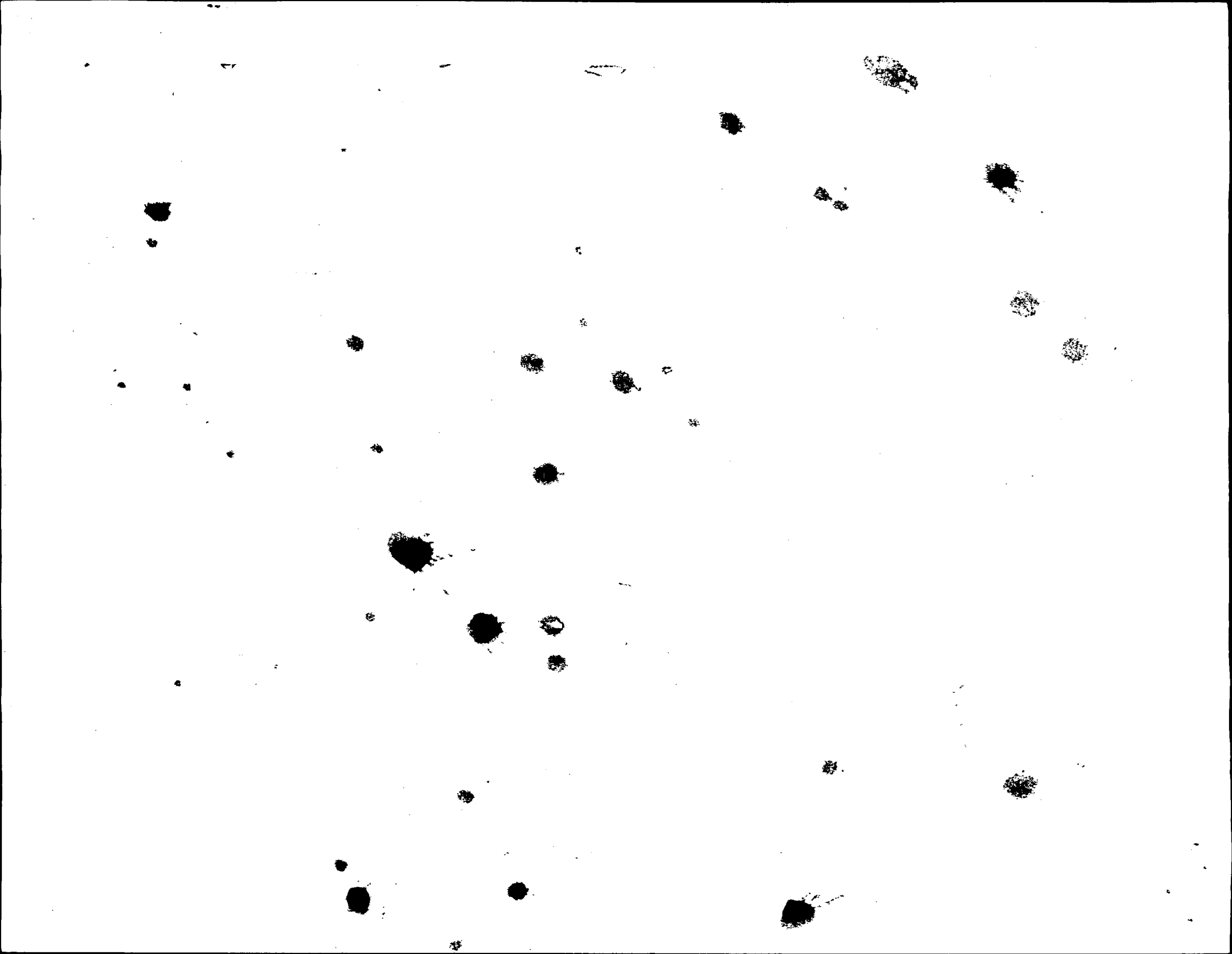
Drawing Name : BLADE FITTING  
Part Number : D3488042  
Drawing Number : D3488 / DSK 101  
Project Number : N/A  
Drawing Revision : B / D  
Material :  
Due Date : 02/05/2008 Qty: 18 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6103003	Round Billet, Aluminum
Comment: Qty.: 1.0000 Each(s)/Unit Total : 18.0000 Each(s) Alluminum Round Billet D6103-003 Batch: <i>36236</i> <i>20 08/04/25</i>		
2.0	DOOSAN LATHE	DOOSAN LATHE
Comment: DOOSAN CNC LATHE 1-Turn as per Dwg DSK 101 & Folio FA627 2-Deburr <i>20 08/04/25</i>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>20 08/04/25</i>		
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA627 & Dwg D3488 2-Deburr <i>20 08/04/25</i>		
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>20 08/04/25</i>		



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Drawing Name: BLADE FITTING

Job Number: 38787

Part Number: D3488042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:15  
3:17  
3:45

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

ALS71032225

INSERT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 ALS7-1032-225 Insert

M100489

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg D3488

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	38787
<b>Description:</b> Blade Fitting, RH		<b>Part Number:</b>	D3488-2
<b>Inspection Dwg:</b> D3488	<b>Rev:</b> B	<b>Page 1 of 1</b>	

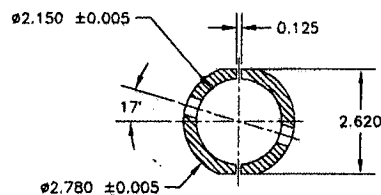
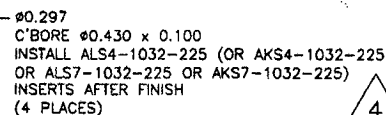
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.130	✓			
2.620	+/-0.010	2.620	✓			
0.793	+/-0.010	.801	✓			
1.351	+/-0.010	1.344	✓			
1.317	+/-0.010	1.314	✓			
90°	+/-0.1°	90°	✓			
1.802	+/-0.010	1.802	✓			
Ø0.508	+0.006/-0.001	Ø.510	✓			
R0.062	+/-0.010	R.062	✓			
1.500	+/-0.010	1.499	✓			
8.000	+0.030/-0.000	8.024	✓			
11.18	+/-0.030	11.181	✓			
Ø0.484	+0.005/-0.001	Ø.486	✓			
1.180	+/-0.010	1.180	✓			
3.150	+/-0.010	3.150	✓			
3.070	+/-0.010	3.062	✓			
0.590	+/-0.010	.590	✓			
0.125	+/-0.010	.128	✓			
1.005	+/-0.010	1.005	✓			
3.500	+/-0.010	3.500	✓			
Ø0.297	+0.005/-0.000	Ø.302	✓			
Ø0.430	+/-0.010	Ø.435	✓			
0.100	+/-0.010	.108	✓			

<b>Measured by:</b> MK	<b>Audited by:</b> DSP	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/04/28	<b>Date:</b> 08/05/12	<b>Date:</b>	N/A

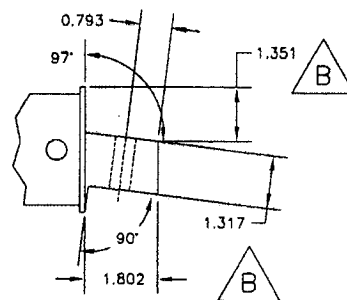
Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	




Handwritten note: *w/o 38787*

Technical drawing of a mechanical part with the following dimensions and features:

- Overall length: 11.18
- Length of main body: 8.000  $\begin{smallmatrix} +0.030 \\ -0.000 \end{smallmatrix}$
- Length of flange: 0.750
- Flange thickness: 0.040  $\begin{smallmatrix} +0.000 \\ -0.004 \end{smallmatrix}$
- Flange hole diameter:  $\varnothing 0.508$  (2 PLACES)
- Flange hole spacing: 1.500
- Top surface radius: R0.062 (TYP)
- Top surface radius: R0.032 (TYP)
- Top surface radius: R0.063 (TYP)



B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	DRAWN BY	 <b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, MA
PH	PH	
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3488
DATE		TITLE
06.03.15		BLADE FITTING
		SCALE
		1:3

RELEASED  
05.05.49 AH  
REC OS  
EIN #789

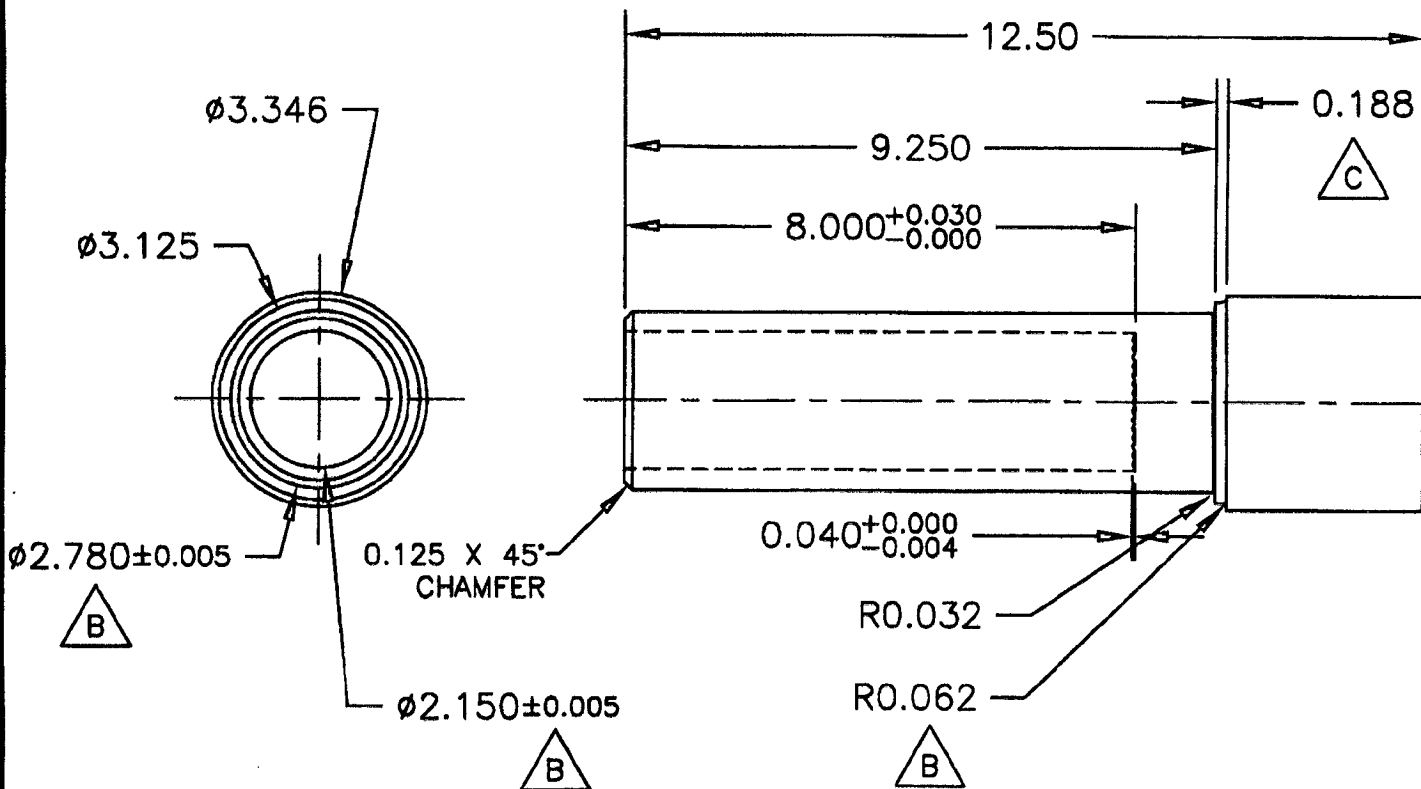
QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3488-041	BLADE FITTING ASSEMBLY (LH)
	X	D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	AL94-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

- 1) MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR  
PER QQ-A-225/9  
(REF. DART MATERIAL SPEC M7075T73R)
- 2) FINISH: ACID ETCH, ALDOPINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) INSTALL INSERTS AFTER POWDER COAT
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
84	84	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
11	11	DSK 101
DATE		TITLE
06.05.09		D3488-1/-2 TURNING DETAIL
A	05.12.21	NEW ISSUE
B	06.03.02	ADD TOLERANCES AND RADIUS
C	06.04.17	0.188 WAS 0.125
D	06.05.09	REMOVE DIAMETER FOR CHAMFER






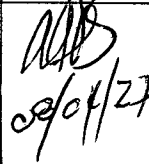
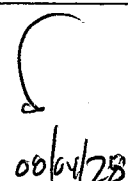
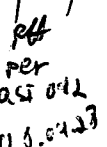
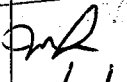
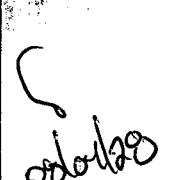
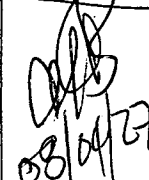

#### DSK 101

- 1) MATERIAL: MAKE FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- 2) FINISH: NONE
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3488-012 PAR #: N/A Fault Category: Prod / Machine Parts NCR: (Yes) No DQA: D Date: 08/05/14  
QA: N/C Closed: D Date: 08/05/15

NCR: <u>38787</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/26	2.0	1 piece, the interior of the hole have a big groove and the small hole at the wrong position. 2 C. Porgones wrong angle of the check Dressing Drill in.	 08/04/28	SCRAP and destroy and no replace <del>BB 36236</del>	 08/04/28	 08/04/28	 08/04/27	 08/04/28
06.04.21	2	CHATTER @ 5.5" DEEP, AND 0.5" LONG AT MOUNTING HOLE LOCATION	 08/04/28	SCRAP B/C NAT MOUNTING HOLE LOCATION and destroy no replace	 08/04/28	 08/04/28	 08/04/27	 08/04/28
		CHATTER @ 7.1" FROM END, AND 0.3" LONG		SCRAP and destroy no replace				

NOTE: Date & initial all entries

